

Date: Thursday, 10/04/2008 10:36:51 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: CABIN FLOOR PROTECTOR	
Job Number	: 38514				Part Number	: D35751	
Estimate Number	: 12663				Drawing Number	: D3575 REV.A	
P.O. Number	:				Project Number	: N/A	
This Issue	: 10/04/2008		S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC				Material	:	
First Issue	: 10/04/2008		Type	SMALL /MED FAB	Due Date	: 18/04/2008	
Previous Run	: 37645				Qty:	4 Um: Each	
Written By	:						
Checked & Approved By	: JD 08-4-10						
Comment	: Est Rev :A New Issue 07-01-22 EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F60029 lexan grey	
		43. MAT NOT PULLED
		Comment: Qty.: 10.6660 sf(s)/Unit Total : 42.6640 sf(s)
	F60029 lexan sheet	
	Batch: 103106 HB 8-4-14	
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET
	1-Cut as per Dwg D3575	
	Dwg Rev: A	HB 8-4-14
	Prog Rev: A	(4)
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		B 8-4-14
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
		C 08-04-14 (X)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
	Deburr if necessary.	FF 08-04-14
		FF 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 10:36:51 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 38514

Part Number: D35751

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/16 (x4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 38514 8/4/16 50

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/16 (x4)

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

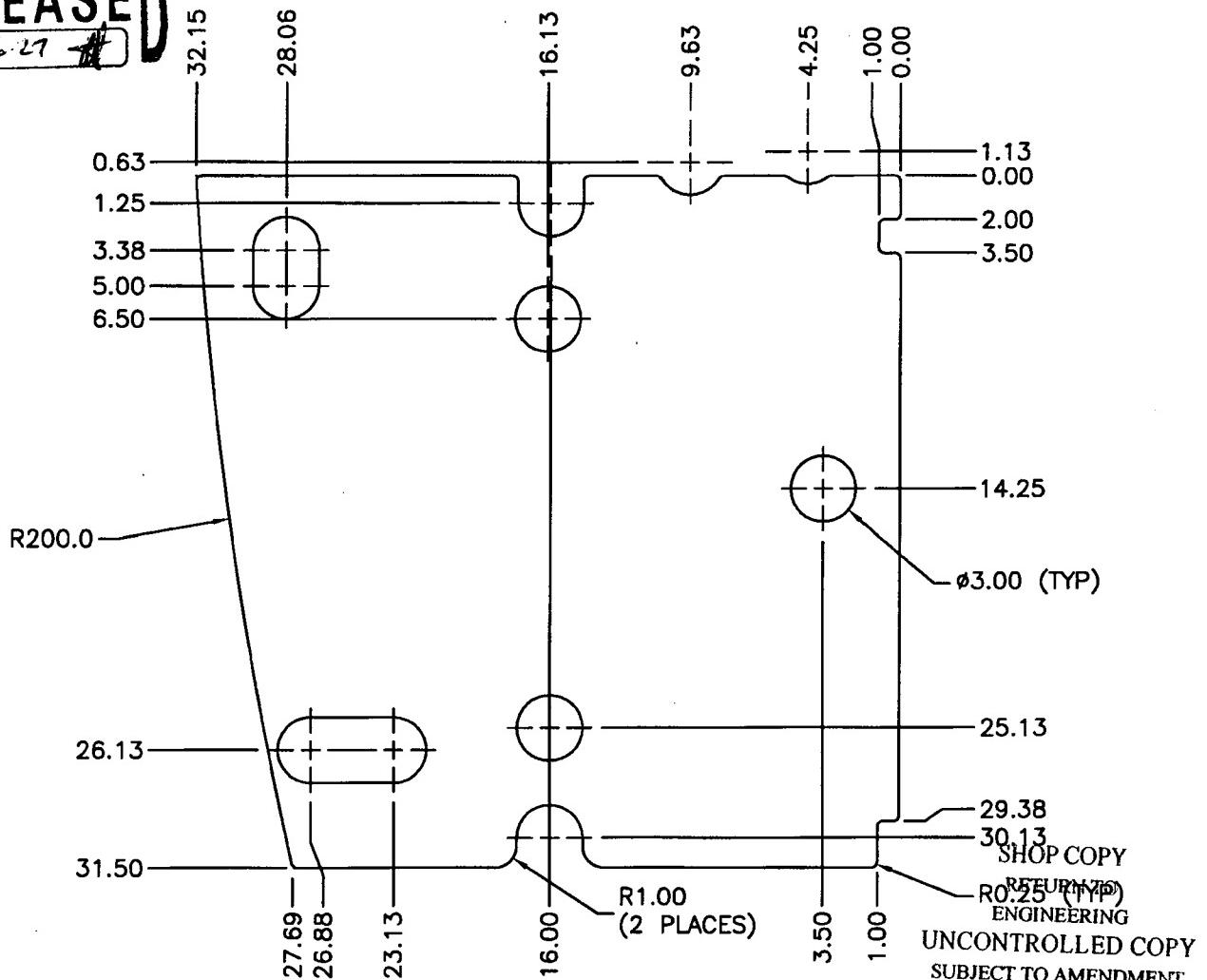
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3575
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR
		SCALE 1:8
A	07.06.08	NEW ISSUE

**RELEASED**  
07.06.08**D3575-1 CABIN FLOOR PROTECTOR (SHOWN)****D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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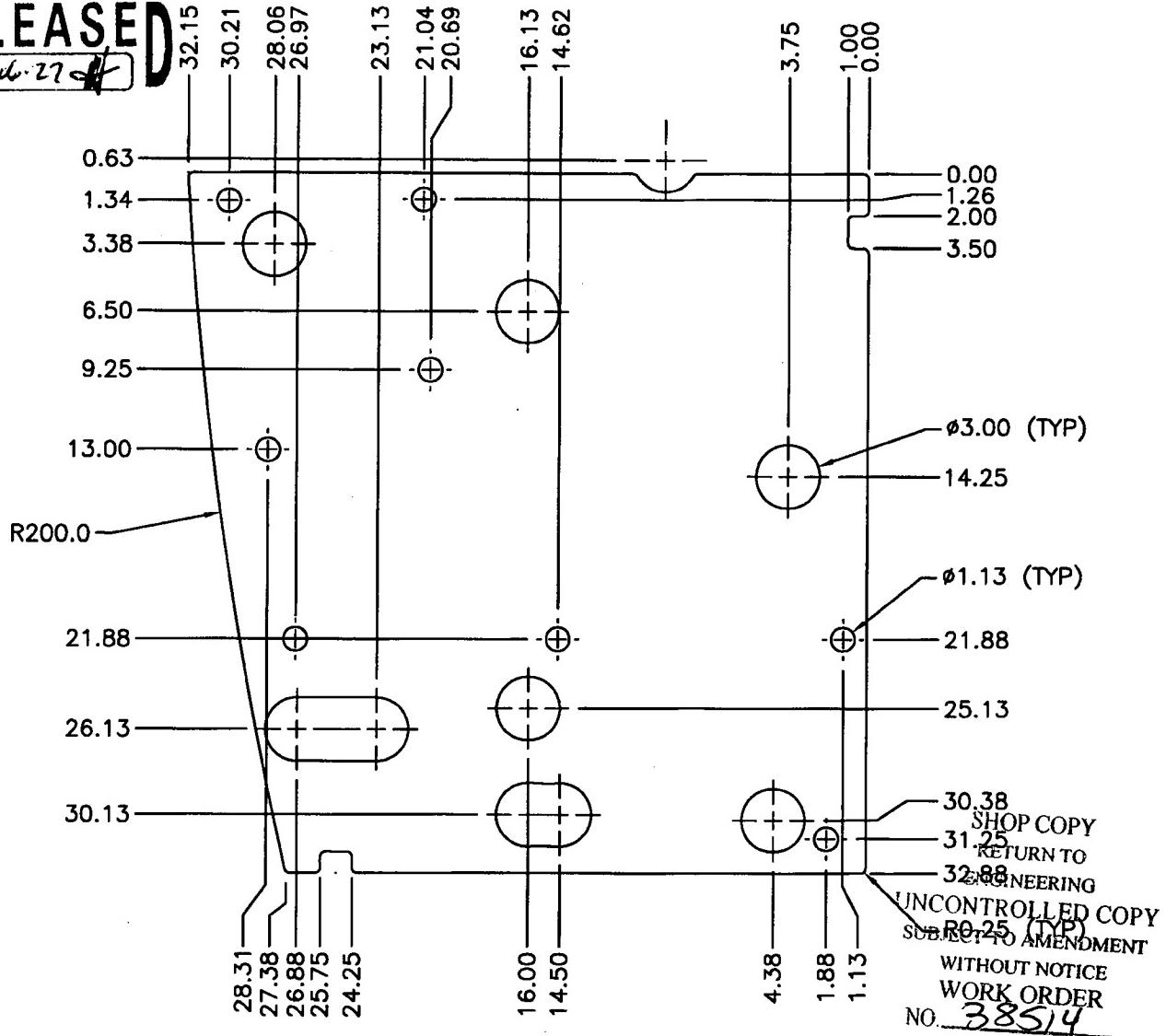
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**DART**

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CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A	SHEET 2 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8	

RELEASED  
07-06-27-07

07.06.27 off



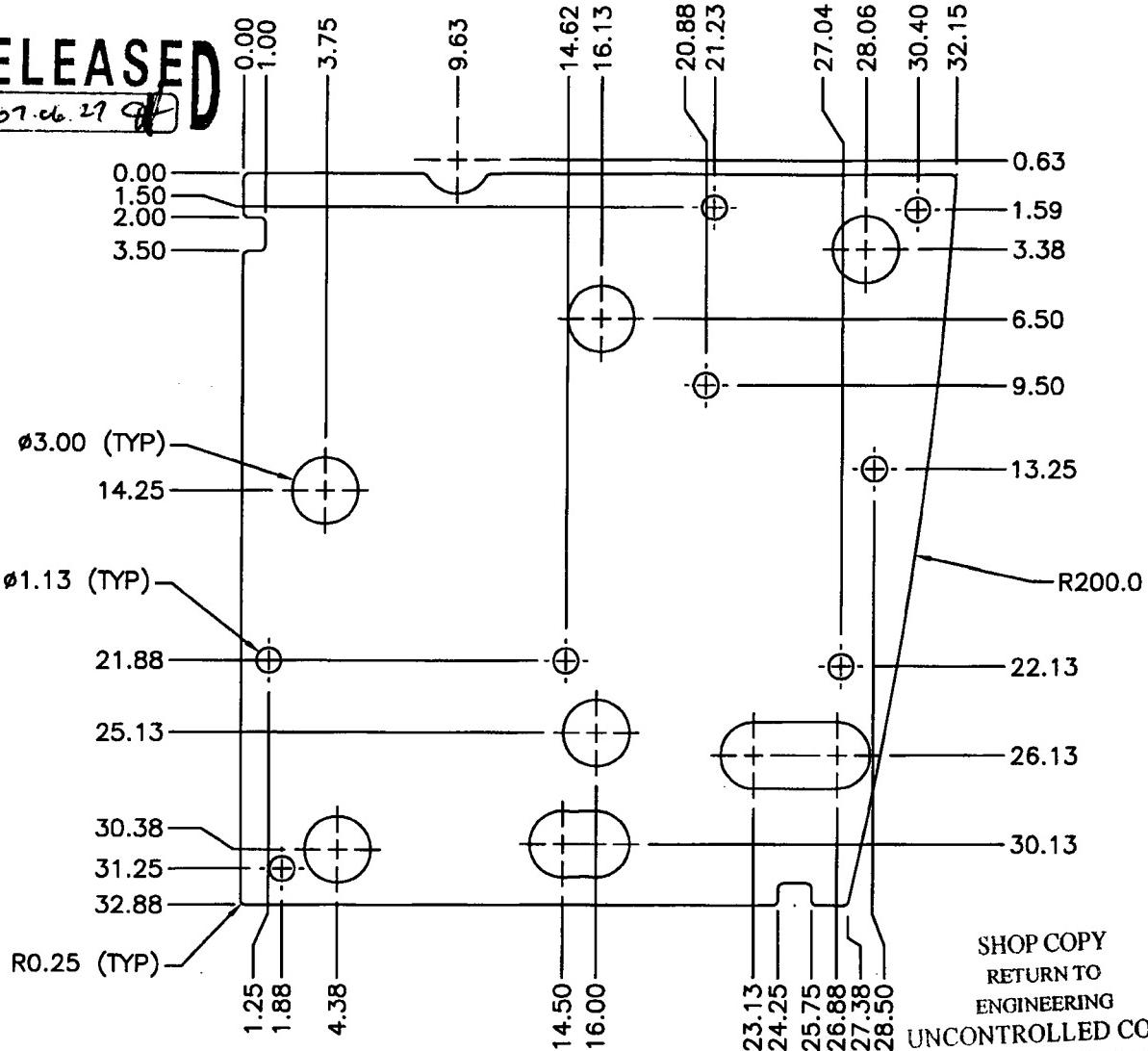
**D3575-3 CABIN FLOOR PROTECTOR**

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
  - 7) CHECK PER TEMPLATE DT8967

**DART**

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CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**  
07.06.08

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT

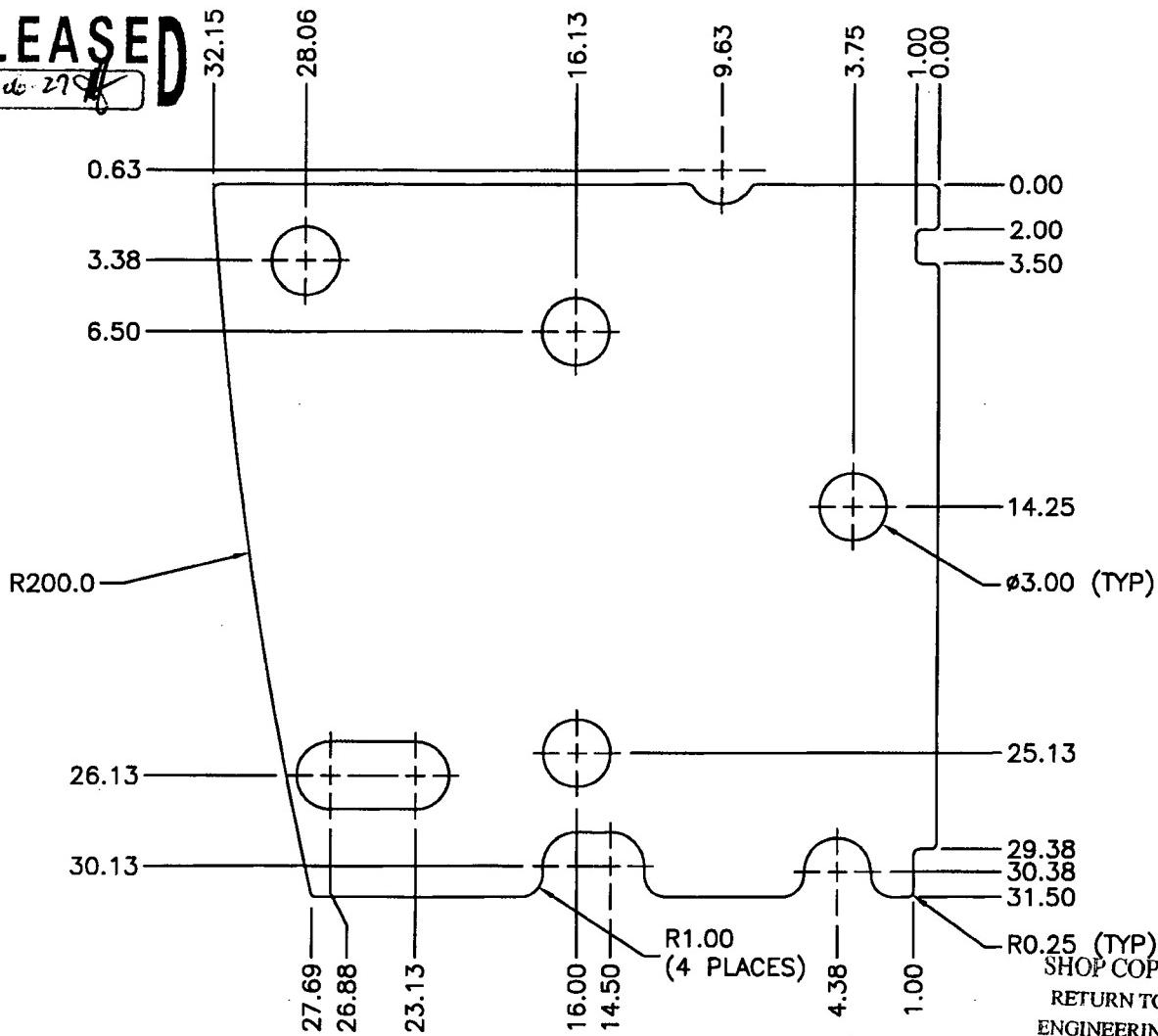
WITHOUT NOTICE  
WORK ORDER  
NO. 38514

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

**DART**

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CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**  
07-06-2008**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)****D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)**

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 38514**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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DART AEROSPACE LTD

Work Order: 38514

Description: CABIN FLOOR PROTECTOR

Part Number: D3575-1

Inspection Dwg: D3575-1 Rev: A

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+ .012 - .001	3.062 *				
1.25	+/- .030	1.25 *				
3.38	+/- .030	3.38 *				
5.00	+/- .030	5.00 *				
6.50	+/- .030	6.50 *				
26.13	+/- .030	26.13 *				
31.50	+/- .030	31.50 *				
2.00	+/- .030	2.00 *				
3.50	+/- .030	3.50 *				
14.25	+/- .030	14.25 *				
25.13	+/- .030	25.13 *				
29.38	+/- .030	29.38 *				
1.00	+/- .030	1.00 *				
3.50	+/- .030	3.50 *				
16.00	+/- .030	16.00 *				
23.13	+/- .030	23.13 *				
26.88	+/- .030	26.88 *				
27.69	+/- .030	27.69 *				
1.00	+/- .030	1.00 *				
4.25	+/- .030	4.25 *				
9.63	+/- .030	9.63 *				
16.13	+/- .030	16.13 *				
28.06	+/- .030	28.06 *				
32.15	+/- .030	32.15 *				

Measured by: HB

Audited by: S

Prototype Approval: L

Date: 8-4-14

Date: 08/04/14

Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	